

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 145763

Friday, May 06, 2016 10:48:15 AM

145763

Page 2

Item ID: D3075-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw(Foot Print Only)

Start Date: 4/21/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140						8	0		45 9-89
QC	Memo	0.12							201608-31
Quality Control									
150	Identify as per dwg & Stock Location: <u>St</u>	0.00				8			
150									
Packaging	Memo	0.06						SEP 0 1 2016	DAS 6 9-89
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.60						SEP 0 1 2016	DAS 21 9-89
Quality Control									

DAS
21
9-89

SEP 0 1 2016

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

8.8

Picklist Print

Friday, May 06, 2016 10:48:14 AM

Page 1
4

Work Order ID: 145763
Parent Item: D3075-1
Parent Item Name: Bearpaw(Foot Print Only)

145763
D3075-1

Start Date: 4/21/2016
Start Qty: 6.00
Required Date: 5/5/2016
Required Qty: 6.00

Comments: IPP Rev:C04.02.19Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
IPP Rev:D Added C'Bores as per Rev B 07-03-28 JLM
IPP Rev:E 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:F 08-11-12 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	60.2330	1	6			

MUHMWB10
UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

Dec 16 / 07 / 12

Location	Loc Qty	Loc Code
MAT	29.9	
m134171	29.9	11
MAT018	30.333	
m131661	1.473	
m134372	28.86	

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								OTHER :																	

DART AEROSPACE LTD		Work Order:	145763
Description: R44 Bearpaw		Part Number:	D3075-1
Inspection Dwg: D3075 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.062x45°	—		Visual-06	
B	0.63	+/-0.030	.635	—		"	
C	0.250	+/-0.010	.255	—		"	
D	0.950	+0.030/-0.010	.9165	—		"	
E	5.50	+/-0.030	5.500	—		"	
F	0.25 x 45°	+/-0.030	.254x45°	—		"	
G	0.900	+/-0.010	.895	—		"	
H	0.375	+/-0.010	.385	—		"	
I	1.30	+/-0.030	1.300	—		"	
J	5.70	+/-0.030	5.700	—		"	
K	0.37	+/-0.030	.375	—		"	
L	3.600	+/-0.010	3.600	—		"	
M	0.260	+0.005/-0.000	.260	—		"	
N	0.93	+/-0.030	.933	—		"	
O	0.30	+0.030/-0.000	.309	—		"	
P	1.08	+/-0.030	1.080	—		"	
Q	5.870	+/-0.010	5.870	—		"	
R	10.14	+/-0.030	10.140	—		M-type	

DAS
14
9-89

DAS
45
9-89

Measured by:	DAS 14 9-89	Audited by:	DAS 45 9-89	Prototype Approval:	N/A
Date:	16/08/30	Date:	2016-08-31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	
B	08.01.16	Dwg Rev updated	KJ/EC/DD	

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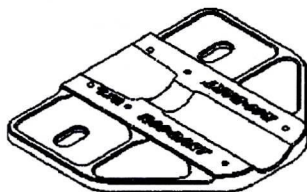
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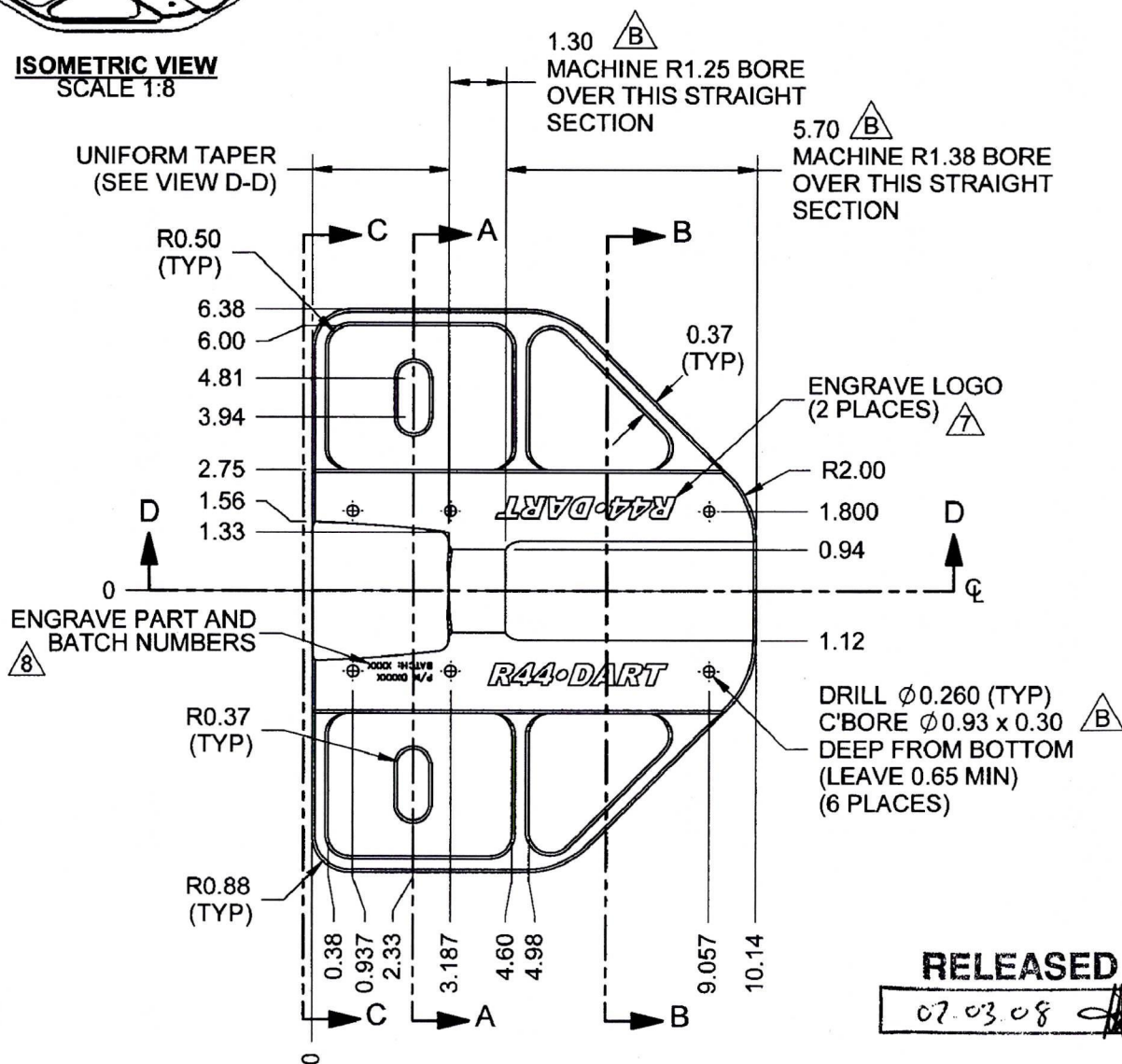
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										



DESIGN <i>[Signature]</i>	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$; ADD QTY(2) HOLES AT (0.937, ± 1.800)	



ISOMETRIC VIEW
SCALE 1:8



RELEASED

07.03.08 *[Signature]*

D3075-1 BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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W/O 1457163

Rev 16/05/09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

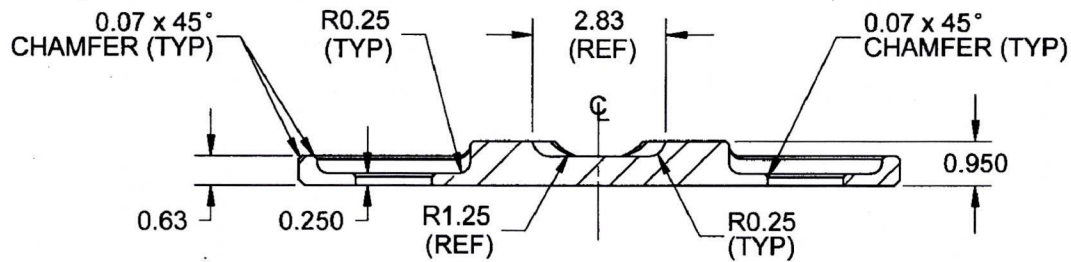
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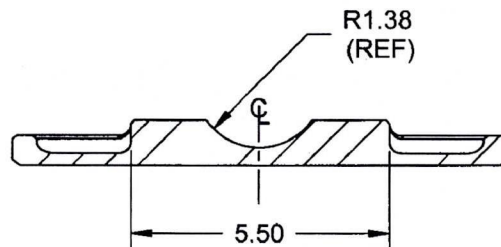
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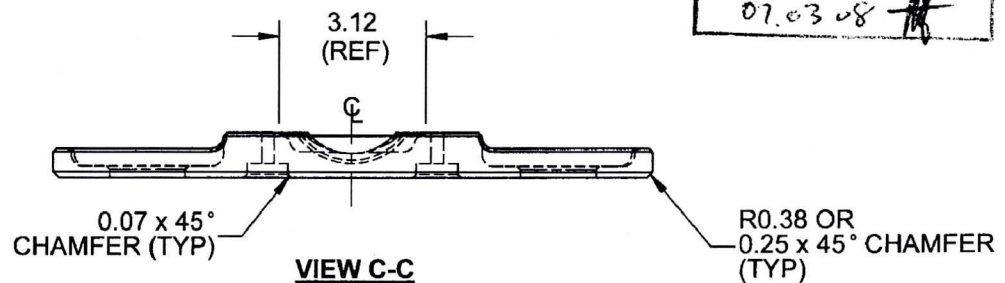
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DATE 07.02.27	TITLE R44 BEARPAW		SCALE 1:4



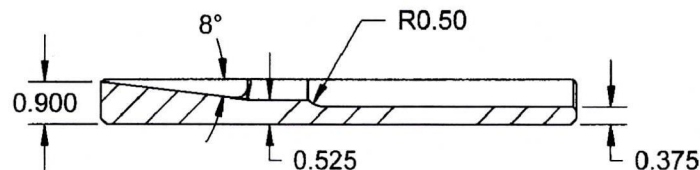
SECTION A-A



SECTION B-B



VIEW C-C



SECTION D-D

RELEASED

07.03.08

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